

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-028720**Date Inspected:** 03-Nov-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** As noted below.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Quality Assurance Inspector (QA) William Clifford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

In Process Visual Inspection

This QA observed, at random intervals, an ABF/JV qualified welder, Xiao Hua Lu #1291, performing Shielded Metal Arc Welding (SMAW) with 3.2mm diameter E7018-MH4-R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1000R. Welding was performed on the bottom of deck access hole location designated as 5E-pp25.9-E5.

This weld is not a Seismic Performance Critical Member (SPCM) member.

Y= 1075, 1400, and 1580.

During welding, ABF Quality Control (QC) Steve Jensen was noted monitoring the welding parameters.

This QA observed, at random intervals, an ABF/JV qualified welder, Guo Wu Chen #1556, performing Shielded Metal Arc Welding (SMAW) with 3.2mm diameter E7018-MH4-R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1004. Welding was performed on the bottom of OBG bottom plate "D" locations designated as pp14 and pp16.

This weld is not a Seismic Performance Critical Member (SPCM) member.

During welding, ABF Quality Control (QC) Andrew Keech was noted monitoring the welding parameters.

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Approximately:

11:00 this QA observed QC Andrew Keech perform Magnetic Particle Testing (MT) of the completed repair weld at OBG bottom plate "D" location designated as pp14. QC performed testing at the locations in this panel point area. QC observed no rejectable indications at the time of testing.

Magnetic Particle Testing

This QA Inspector performed Magnetic Particle Testing (MT) of completed repair on the bottom of OBG bottom plate "D" location designated as pp14. This QA observed no rejectable indications at the time of testing. This QA Inspector generated a TL-6028 MT report on this date. The completed work observed at this location appeared to be in compliance with the contract specifications.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Conversation was relevant to welding performed during this shift.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

Inspected By:	Clifford, William	Quality Assurance Inspector
Reviewed By:	Reyes, Danny	QA Reviewer
